

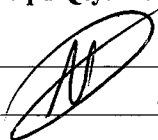
Work Order ID 163607

Monday, July 03, 2017 3:10:53 PM

163607

Page 1

Item ID: D2804-2 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket
 Start Date: 7/4/2017 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 7/17/2017 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan:  Date: JUL 03 2017 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2804	D								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.60							
FLOW CNC Waterjet	1-Cut as per File D2804-1-2_BLANK								
	Dwg Rev: <u>D</u>								
	Prog Rev: <u>D</u>								
	CHECK WITH MACHINIST FOR DIRECTION OF MATERIAL								
	BOW/WRAPPAGE PRIOR TO CUTTING								
	2-Deburr if necessary								
110	HAAS CNC VERTICAL MACHINING #1	0.68							
110									
HAAS 1	Memo	2.17							
HAAS CNC vertical machine #1	Machine as per folio FA103								

(4) 0 2017/07/03

(4) 0 17/07/16 DAS 45 9-89

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Page 2

Item ID: D2804-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 7/4/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/17/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00				4	0		
120									
QC	Memo	0.04							
Quality Control									45 9-89
121		0.00				4	0		
121									
Mill Conv	Memo	0.00							
Conventional Milling Machine	COUNTERSINK BACK SIDE AS PER DWG								32 9-89 17-07-25
122	QC2- Inspect parts off machine FAI/FAIB	0.00				4	0		
122									
QC	Memo	0.00							
Quality Control									32 9-89 17-07-25

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JUL 27 2017

Work Order ID 163607***163607***

Page 4

Monday, July 03, 2017 3:10:53 PM

Item ID: D2804-2**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Bracket**Start Date:** 7/4/2017 **Start Qty:** 4.00 ***4*****Cust Item ID:****Required Date:** 7/17/2017 **Req'd Qty:** 4.00 ***4*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

160

Identify as per dwg & Stock Location: **5475**

0.00

160

Packaging

Memo

0.04

Packaging

4 **DAS** **6** **JUL 31 2017** **9-89**

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.40

Quality Control

17/8/2017**AUG 01 2017**

Picklist Print

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Page 1

Work Order ID: 163607

163607

Parent Item: D2804-2

D2804-2

Parent Item Name: Bracket

Start Date: 7/4/2017

Required Date: 7/17/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A00.11.06New IssueEC
IPP B06.05.30 Blanks on wtjetEC
IPP Rev:C As per Rev C 06-11-09 JLM
IPP Rev:D Removed Tumbling 08-09-10 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X12.00 0		Purchased		No		100	f	9.5000	1.33	5.6			

M6061T6B0 500X12 000

**

07/17/17

6061-T6 Bar .500 x 12.00

Location

Loc Qty

Loc Code

MAT001

9.5

m136697

9.5

135987

5.8

DART AEROSPACE LTD		Work Order:	163607
Description: STA 155 Bracket		Part Number:	D2804-2
Inspection Dwg: D2804 Rev: D		Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	0.125	✓		Kt-05	vern.
0.125	+/-0.010	0.125	✓		" "	" "
R0.125	+/-0.010	0.125	✓		—	R-6
0.250	+/-0.010	0.247	✓		Kt-04	mic.
0.250	+0.000/-0.005	0.248	✓		" "	" "
0.875	+0.000/-0.001	0.875	✓		Kt-05	vern.
R0.062	+/-0.010	0.062	✓		—	R-6
Ø0.757	+0.005/-0.000	0.757	✓		Kt-05	vern.
R0.625	+/-0.010	0.625	✓		—	R-6
12.304	+/-0.005	12.304	✓		31006	H-6
Ø0.507	+0.000/-0.001	0.507	✓		Kt-05	vern.
0.437	+0.000/-0.001	0.437	✓		31006	H-6
0.608	+0.000/-0.001	0.608	✓		31006	H-6
Ø0.191	+0.005/-0.000	0.191	✓		Kt-05	vern.
1.420	+0.001/-0.001	1.420	✓		" "	" "
0.250 deep	+/-0.010	0.250	✓		" "	" "
6.933	+/-0.005	6.933	✓		31006	H-6
7.578	+/-0.005	7.578	✓		" "	" "
0.500	+/-0.010	0.500	✓		Kt-05	vern.
Ø0.385 x 100°	+/-0.010 x +/-0.5°	0.382	✓		Caliper	JCL-08

Measured by: Kt / DAS 386 RC	Checked by: 44 9.29	QC Inspector:
Date: 17-07-16 / 17-07-25	Date: 17-07-25	Date:

Engineering Approval: (if necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	
B	05.04.25	Added 0.500 dimension	KJ/JLM	
C	06.11.10	Revised per drawing revision C	KJ/JLM	
D	16.08.29	Dwg Rev updated	KJ	
E	16.10.13	Dimension added	KJ	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 1636071A
JUL 03 2017

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D2804-041	BRACKET ASSY
		X	D2804-042	BRACKET ASSY
1	1		D2804-1	STA 155 BRACKET
2		1	D2804-2	STA 155 BRACKET
3	1		D2805-1	STOP
4		1	D2805-2	STOP
5	1	1	D2809	SPACER
6	4	4	D3672-15	PHENOLIC WASHER
7	2	2	AN3C16A	BOLT
8	2	2	MS21043-3	NUT, SELF-LOCKING

D2804-1
STA 155 BRACKET

9
AN3C16A BOLT
D3672-15 PHENOLIC WASHER, 2X/D
MS21043-3 NUT
2 PL

D2809
SPACER
8

D2804-2
STA 155 BRACKET

9
AN3C16A BOLT
D3672-15 PHENOLIC WASHER, 2X/D
MS21043-3 NUT
2 PL

D2805-1
STOP
8

D2804-041 BRACKET ASSY

D2809
SPACER
8

D2805-2
STOP
8

D2804-042 BRACKET ASSY

NOTES:

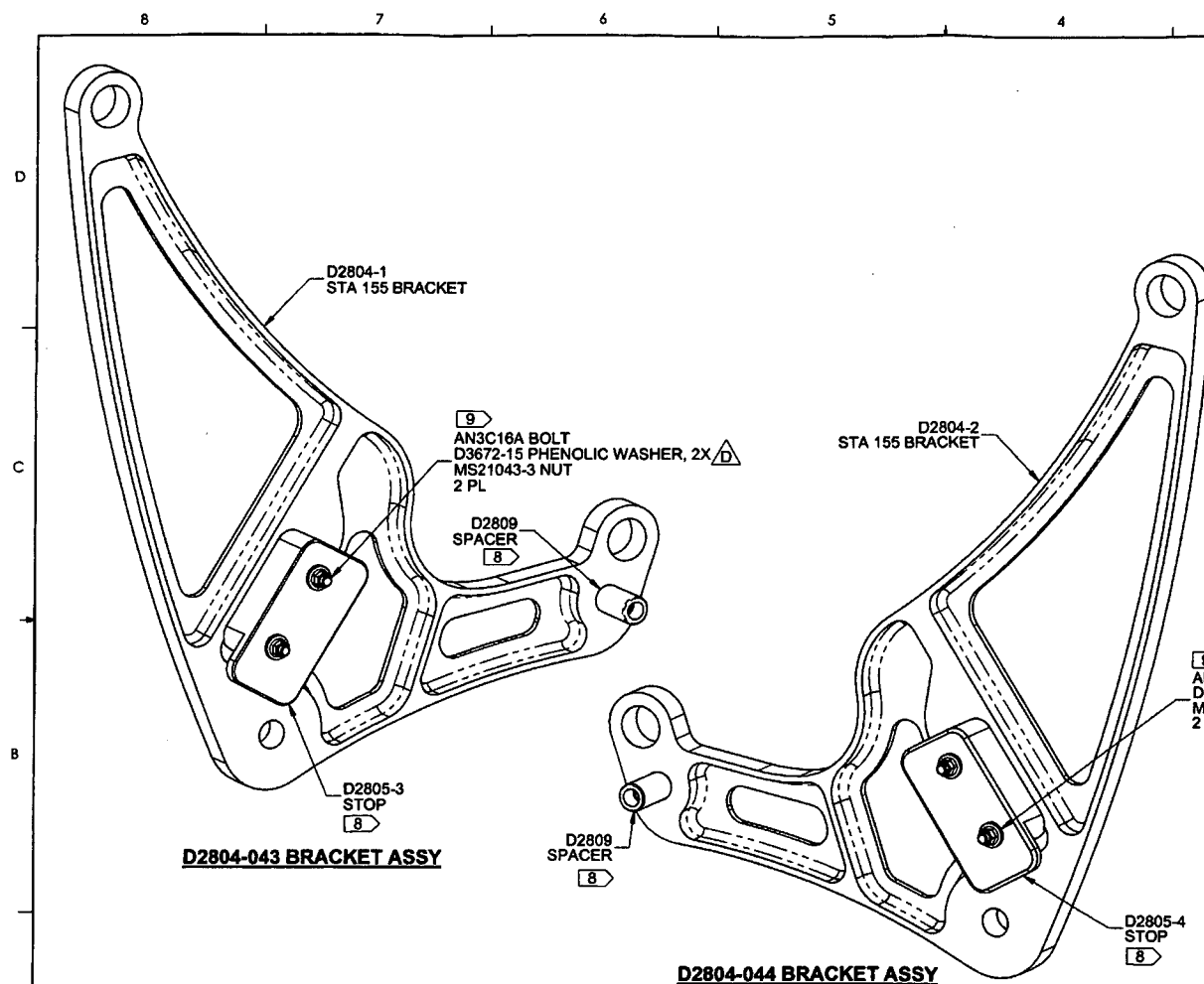
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GLOSS WHITE" (4.3.5.1) OR "GREY SANDTEX" (4.3.5.6) OR "BLACK SANDTEX" (4.3.5.7) OR "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 1.37 lbs
- 8) PRESS D2805-X AND D2809 INTO PLACE PRIOR TO POWDER COAT
- 9) INSTALL BOLT WITH LPS-3 CORROSION INHIBITOR, ENSURE NO LPS-3 ON THREADS

RELEASED

2016 JUN 22
EKN 16-661

D	REVISE TO CURRENT FORMAT: D3672-15 WAS NAS1815H3; MS21043-3 WAS MS21042-3; ADD CSINK (SECTIONS E-E AND J-J). REF: PAR16-489. D8-3/4: 2.656 WAS 2.854 REASON: CAD ERROR.	MB	16.04.11
C	CHANGE GEOMETRY TO ADD CLEARANCE	CP	06.10.16
B	ADD CUTOUTS AND -043/-044	CP	04.11.22
A	NEW ISSUE	CP	00.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	JLM	D2804	SHEET 1 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STA 155 BRACKET	NTS
DATE	16.04.11	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED



ITEM	QTY -043	QTY -044	P/N	DESCRIPTION
	X		D2804-043	BRACKET ASSY
		X	D2804-044	BRACKET ASSY
1	1		D2804-1	STA 155 BRACKET
2		1	D2804-2	STA 155 BRACKET
3	1		D2805-3	STOP
4		1	D2805-4	STOP
5	1	1	D2809	SPACER
6	4	4	D3672-15	PHENOLIC WASHER
7	2	2	AN3C16A	BOLT
8	2	2	MS21043-3	NUT, SELF-LOCKING

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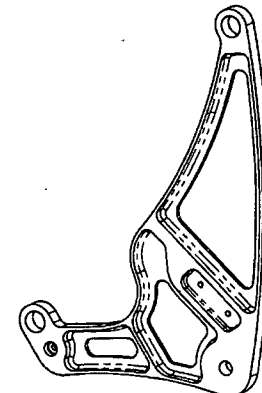
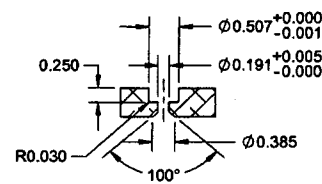
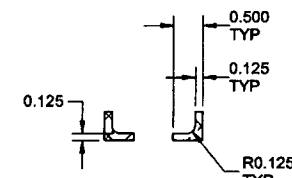
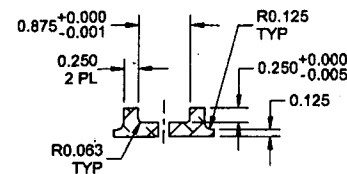
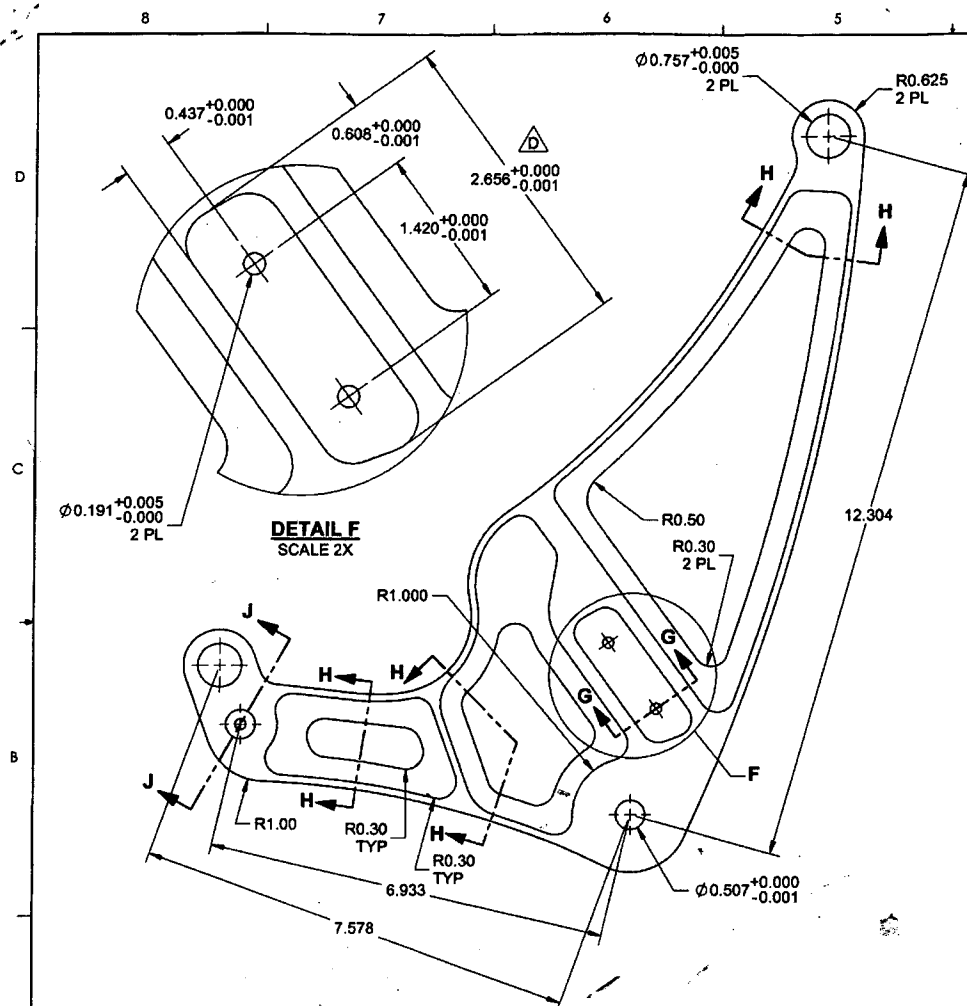
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GLOSS WHITE" (4.3.5.1) OR "GREY SANDTEX" (4.3.5.6) OR "BLACK SANDTEX" (4.3.5.7) OR "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
 - 7) WEIGHT: 1.37 lbs
 - 8) PRESS D2805-X AND D2809 INTO PLACE PRIOR TO POWDER COAT
 - 9) INSTALL BOLT WITH LPS-3 CORROSION INHIBITOR, ENSURE NO LPS-3 ON THREADS

RELEASED

2016 JUN 22 *qp*

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	JLM	D2804	SHEET 2 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STA 155 BRACKET	NTS
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APPROVED



D2804-2 STA 155 BRACKET

RELEASED

2016 JUN 22 09

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: R0.030 TO 0.063 ON ALL EDGES
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.01 lbs
- 8) MACHINE PER PART FILE D2804-1_REV.D.SLDPRT

APPROVED

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	JLM	D2804	SHEET 4 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STA 155 BRACKET	NTS
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